

Work Order ID 153186-2

Wednesday, November 09, 2016 12:41:37 P

SPLIT-602
647.1404
B153186
REV B

153186

SHIP NOV 29

Page 1

Item ID: 647.1404

Revision ID:

Item Name: Upper Cutter Assembly

Start Date: 11/9/2016 Start Qty: 4.00

Required Date: 11/11/2016 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: VS

Date: 11/11/16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

647.1400

B

110 Pick Kit

0.00

DEC 15 2016

110

Packaging

Memo

0.00

Packaging

120

0.00

120

Small Fab

Memo

0.04

Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598

exp. date: 04/18

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.01

Quality Control

CCK 048

DAS
38
9-89

JAN 19 2017

DAS
38
9-89
JAN 18 2017

Work Order ID 153186

Wednesday, November 09, 2016 12:41:37 P

153186

Page 2

Item ID: 647.1404 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Cutter Assembly
Start Date: 11/9/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 11/11/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Packaging Packaging	Identify as per dwg & Stock Location <i>SE</i> Memo ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***	0.00 0.01		<i>3</i>		<i>7</i>	<i>DAS</i> <i>9-89</i>	<i>17/01/19</i> <i>90291338</i>	
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.07		<i>17/01/23</i>			<i>DAS</i> <i>9-89</i>	<i>DEC 16 2016</i>	

AA
DEC 16 2016

DAS
21
9-89

JAN 23 2017

Picklist Print

Page 1

Wednesday, November 09, 2016 12:41:45 PM

Work Order ID: 153186

153186

Parent Item: 647.1404

647 1404

Parent Item Name: Upper Cutter Assembly

Start Date: 11/9/2016

Required Date: 11/11/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 16.03.28 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9703 *646 9703* Cutter Sub Assembly		Manufactured	No				Each	1.0000		4			
Location Loc Qty Loc Code													
CCK013 1													
148517 1													
647.1513 *647 1513* Upper Deflector		Manufactured	No				Each	3.0000		4			
Location Loc Qty Loc Code													
CCK015 3													
146730 3													
MS21042L08 *MS21042L 08* Nut		Purchased	No				Each	1,060.000		12			
Location Loc Qty Loc Code													
GA 50													
m135274 50													
ST303 1010													
m135672 10													
m135766 200													
m135948 300													
m135978 500													

NOV 16 2016
153313
JAN 11 2017

NOV 16 2016
153551x3

NOV 16 2016

Picklist Print

Wednesday, November 09, 2016 12:41:45 PM

Page 2

Work Order ID: 153186

153186

Parent Item: 647.1404

647.1404

Parent Item Name: Upper Cutter Assembly

Start Date: 11/9/2016

Required Date: 11/11/2016

Start Qty: 4.00

Required Qty: 4.00

MS27039-08-19

Purchased

No

Each

315.0000

12

MS27039-08-19

NOV 16 2016

Screw

Location

Loc Qty

Loc Code

GA

182

m135948

182

ST277

133

m135865

33

m136042

100

Each

1,519.000

24

NAS1149FN832P

Purchased

No

NAS1149FN832P

NOV 16 2016

Washer

Location

Loc Qty

Loc Code

GA

1389

M133769

89

M135058

1300

ST263

130

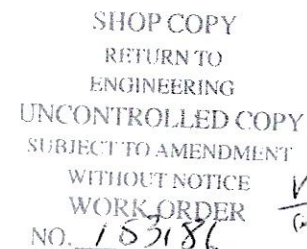
M135603

130

PRINTED COPY OF THIS DOCUMENT IS FOR REFERENCE ONLY AND IS UNCONTROLLED

REV	DESCRIPTION	DATE	APPROVED
	LAST PROTYPE REVISION: PPI		N/C
N/C	INITIAL RELEASE	04/15/00	P. BRAVO
A	INCORPORATED FCMS (2947, 8, 0291)	04/07/01	P. BRAVO
B	INCORPORATED FCMS 05530	02/29/16	P. BRAVO

2. APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 6, & 7 UPON ASSEMBLY



1				10	647.1513	UPPER DEFLECTOR			
1				9	646.9703	CUTTER SUB ASSY			
	1			8	646.9702	CUTTER SUB ASSY			
		1		7	647.1501	LOWER DEFLECTOR ASSY			
	1		1	6	647.1510	UPPER DEFLECTOR			
A/R	A/R	A/R	A/R	5	601.2045	RTV, LOCITE 598			
3	3	3	3	4	601.1541	NUT		MS21042L08	
3	3	3	3	3	601.2765	SCREW		MS27039-0819	
6	6	6	6	2	601.2764	WASHER		NAS1149FN832P	
		1	1	1	646.9701	CUTTER SUB ASSY			
X					647.1404	CUTTER ASSY (UPPER)			
	X				647.1403	CUTTER ASSY (UPPER)			
		X			647.1402	CUTTER ASSY (LOWER)			
			X		647.1401	CUTTER ASSY (UPPER)			
1404	1403	1402	1401	FIND	PART #	DESCRIPTION		MAT'L	SPEC

QTY		ORIGINAL DATE		PARTS LIST	
NEXT ASSY (\$)		OR (MOM) (Y)		 3030 ENTERPRISE C1 SUITE A VISTA, CA 92081 (760)-724-5300	
647.1300		CECHECKER 1. GARDNER 2. BRAYCO 3. BRAYCO 04-15-09			
		PRICING APPROVAL 04-15-09		AEROSPACE INDUSTRIES INC. 1000 AIRPORT AEROSPACE	
		CONTRACT NO.		CUTTER ASSY	
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .005 3 PLACE DECIMALS ± .0005 ANGLES ± .5°		528 CAGE CODE 6 074M6 SCALE NONE	
				DWG. NO. 647.1400 SHEET 1 OF 1	